



Dart Aerospace Ltd.
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K6A 1K7
Canada

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D350-636-012
Job Sheet 200609



Part No: D350-636-012

Job Qty: 1 pcs

Part Name: Skidtubes RH, Std Wearplates, DART (Apical) Cylindrical/Aerazur Float Comp.



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/13/19

Job Tracking No:

Due Date: 10/18/19

Created By: Marie Lajeunesse

Type: Stock

Description: SIOP

Note: DWG D2750-042 REV.H IPP Rev:I 02.09.25 IPP Rev:J 06-03-23 As per Rev D IPP Rev:K 06-07.13 As per dsi9343 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC IPP Rev:M 08-04-22 DD verified:EC IPP Rev:N 08-09-23 revF DD verified:ec IPP Rev:O 09-02-06 per PAR09-010 DD verf:EC IPP Rev:P 10.06.22 revise seq110 DD verf:EC IPP Rev:Q 10.10.01 as per IIN revH DDverf:EC IPP REV:R 13.08.27 PER ECN13-594 DD VERF:JLM IPP REV:S 18.11.12 AS PER DWG REV.H DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Skidtubes - 1	1 pcs	10/18/19	10/18/19	0.00	4.36	Skidtubes - 1		DO
							Skidtubes - 2		
							Skidtubes - 3		
							Skidtubes - 4		
							Skidtubes - 5		
							Skidtubes - 6		
							Skidtubes - 7		
120	QC 10	1 pcs	10/18/19	10/18/19	0.00	0.00	QC 10 - 10		DAS OCT 09 2019
							QC 10 - 18		
							QC 10 - 24		
							QC 10 - 43		
							QC 10 - 50		
							QC 10 - 58		
							QC 10 - 9		
130	QC 5	1 pcs	10/18/19	10/18/19	0.00	0.00	QC 5 - 10		DAS OCT 09 2019
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		

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9/13/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

140 Handfinish - 1-1 Chemical-
B4B1
pcs

10/18/19

0.00 0.91

QC 5 - 50

QC 5 - 30

QC 5 - 40

QC 5 - 61

QC 5 - 81

Handfinish - 1 - 1 - B4B

Handfinish - 1 - 2 - B4B

Handfinish - 1 - 3 - B4B

Handfinish - 1 - 4 - B4B

Handfinish - 1 - 5 - B4B

Handfinish - 1 - 6 - B4B

Handfinish - 1 - 7 - B4B

Handfinish - 1 - 8 - B4B

Handfinish - 1 - 9 - B4B

Handfinish - 1 - 10 -
B4BHandfinish - 1 - 11 -
B4BHandfinish - 1 - 12 -
B4BHandfinish - 1 - 13 -
B4BHandfinish - 1 - 14 -
B4BHandfinish - 1 - 15 -
B4BHandfinish - 1 - 16 -
B4BHandfinish - 1 - 17 -
B4BHandfinish - 1 - 18 -
B4BHandfinish - 1 - 19 -
B4BHandfinish - 1 - 20 -
B4BHandfinish - 1 - 21 -
B4BHandfinish - 1 - 22 -
B4B

OCT 21 2019

150 QC 7

1
pcs

10/18/19

0.00 0.00

QC 7 - 10

QC 7 - 13

QC 7 - 14

QC 7 - 15

QC 7 - 17

QC 7 - 18

QC 7 - 19

QC 7 - 2

QC 7 - 28

QC 7 - 3

QC 7 - 30

QC 7 - 34

QC 7 - 36

QC 7 - 37

QC 7 - 41

QC 7 - 47

QC 7 - 48

QC 7 - 51

QC 7 - 58

QC 7 - 59

QC 7 - 60

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				QC 7 - 9	
				QC 7 - 68	
				QC 7 - 50	
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 7679	
160 Skidtubes - 2 - B4B	1 pcs	10/18/19	0.00 4.36	Skidtubes - 1 - B4B	DD
			1.45 TF	Skidtubes - 2 - B4B	DD
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	TF
			2.57	Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
170 QC 10	1 pcs	10/18/19	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
180 QC 5	1 pcs	10/18/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
190 Handfinish - 2-1 Pressure-B4B	1 pcs	10/18/19	0.00 0.91	Handfinish - 2 - 1 - B4B	
				Handfinish - 2 - 2 - B4B	
				Handfinish - 2 - 3 - B4B	
				Handfinish - 2 - 4 - B4B	
200 Spray Paint - 2 - B4B	1 pcs	10/18/19	0.00 0.69	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
205 Outsource	1 pcs	10/18/19		ATE003-VC	5
210 QC 14	1 pcs	10/18/19	0.00 0.00	QC 14 - 15	
				QC 14 - 2	
				QC 14 - 34	
				QC 14 - 41	
				QC 14 - 51	
				QC 14 - 58	

				QC 14 - 59	
				QC 14 - 9	
				QC 14 - 68	
				QC 14 - 40	
				QC 14 - 19	
				QC 14 - 43	
				QC 14 - 24	
				QC 14 - 61	
				QC 14 - 81	
230	Handfinish - 4-1-Assembly-B4B	1 pcs	10/18/19	0.00 0.91	Handfinish - 4 - 1 - B4B
					Handfinish - 4 - 10 - B4B
					Handfinish - 4 - 11 - B4B
					Handfinish - 4 - 12 - B4B
					Handfinish - 4 - 13 - B4B
					Handfinish - 4 - 14 - B4B
					Handfinish - 4 - 15 - B4B
					Handfinish - 4 - 2 - B4B
					Handfinish - 4 - 3 - B4B
					Handfinish - 4 - 4 - B4B
					Handfinish - 4 - 5 - B4B
					Handfinish - 4 - 6 - B4B
					Handfinish - 4 - 7 - B4B
					Handfinish - 4 - 8 - B4B
					Handfinish - 4 - 9 - B4B
240	QC 5	1 pcs	10/18/19	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
					QC 5 - 61
					QC 5 - 81
250	Packaging 1-1 - Pick Kit - B4B	1 pcs	10/18/19	0.00 0.00	Packaging 1 - 1 - B4B
					Packaging 1 - 2 - B4B
					Packaging 1 - 3 - B4B
					Packaging 1 - 4 - B4B
					Packaging 1 - 5 - B4B
					Packaging 1 - 6 - B4B
					Packaging 1 - 7 - B4B
					Packaging 1 - 8 - B4B
					Packaging 1 - 9 - B4B
					Packaging 1 - 10 - B4B
					Packaging 1 - 11 - B4B

Handfinish - 4 - 10 - B4B

Handfinish - 4 - 11 - B4B

Handfinish - 4 - 12 - B4B

Handfinish - 4 - 13 - B4B

Handfinish - 4 - 14 - B4B

Handfinish - 4 - 15 - B4B

Handfinish - 4 - 2 - B4B

Handfinish - 4 - 3 - B4B

Handfinish - 4 - 4 - B4B

Handfinish - 4 - 5 - B4B

Handfinish - 4 - 6 - B4B

Handfinish - 4 - 7 - B4B

Handfinish - 4 - 8 - B4B

Handfinish - 4 - 9 - B4B

QC 5 - 10

QC 5 - 12

QC 5 - 17

QC 5 - 18

QC 5 - 19

QC 5 - 22

QC 5 - 24

QC 5 - 3

QC 5 - 43

QC 5 - 49

QC 5 - 51

QC 5 - 58

QC 5 - 68

QC 5 - 9

QC 5 - 50

QC 5 - 30

QC 5 - 40

QC 5 - 61

QC 5 - 81

Packaging 1 - 1 - B4B

Packaging 1 - 2 - B4B

Packaging 1 - 3 - B4B

Packaging 1 - 4 - B4B

Packaging 1 - 5 - B4B

Packaging 1 - 6 - B4B

Packaging 1 - 7 - B4B

Packaging 1 - 8 - B4B

Packaging 1 - 9 - B4B

Packaging 1 - 10 - B4B

Packaging 1 - 11 - B4B

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DAS 74 9-89

NOV 15 2019

				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	
				Packaging 1 - 28 - B4B	
				Packaging 1 - 29 - B4B	
				Packaging 1 - 30 - B4B	
				Packaging 1 - 31 - B4B	
				Packaging 1 - 32 - B4B	
				Packaging 1 - 33 - B4B	
				Packaging 1 - 34 - B4B	
				Packaging 1 - 35 - B4B	
				Packaging 1 - 36 - B4B	
260 QC 4	1 pcs	10/18/19	0.00 0.00	QC 4 - 28	
				QC 4 - 58	
				QC 4 - 69	
				QC 4 - 9	
				QC 4 - 46	
				QC 4 - 68	
				QC 4 - 72	
				QC 4 - 74	
270 Packaging 3-1 - Stock - B4B	1 pcs	10/18/19	0.00 0.00	QC 4 - 75	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	

				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	DAS
				Packaging 3 - 34 - B4B	21 NOV 19 2019
				Packaging 3 - 35 - B4B	5:39
				Packaging 3 - 36 - B4B	
275 DC - 1 - B4B	1	10/18/19	0.00 0.00	DC - 1 - B4B	DAS
	pcs			DC - 2 - B4B	21 NOV 19 2019
280 QC 21 - FG	1	10/18/19	0.00 0.00	QC 21 - FG - 21	5:39
	pcs			QC 21 - FG - 70	DAS
				QC 21 - FG - 53	21 NOV 19 2019

Part Op 110 - (Skid tubes) 1- Pick D2600-3 Bent Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill bit and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE. 6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297". 7- Open up holes of Detail J to 0.297" (total of 2 holes per side) 8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004 9- Grind welds flush as per Dwg D2750

120 - (QC10- Inspect visual per QSI004- ground welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 160 - (Skid tubes) 1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750. 2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750. 3- Open float holes using uni-bit to .500" (4 per Side) 4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9) 5- Deburr and blow out all chips from inside of tube 6- Prepare tube for welding, remove alodine as required. 7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: 5200625 exp. date: 07/25/20 **ATTN: USE I-BEAM LOCATION AID (BLADE FITTING)*** 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: 189011 9- At section AP-AP drill out x-bolt spacer to 0.404" 10-Grind welds flush as per Dwg D2750 11- Spot face ground handling holes section (total of 4 places per side) as per dwg D2750 12- Deburr holes, ensure tube is free of all scratches before sending to paint.

170 - (QC10- Inspect visual per QSI004- ground welds)
 180 - (QC5- Inspect part completeness to step on W/O) ***VERIFY C'BOARD IS GOOD***
 190 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - (Spray Paint / NDT Room) 1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: 5200299 2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: 5213125

210 - (QC14- Inspect Spray Paint) Inspect for foreign object per QSI 024

230 - (Assemble as per dwg) 1-Install inserts as per dwg D2750 2-Inspect for Foreign Objects 3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: 5200625 EXP DATE: 20-3-23 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: 5138843 5-Coat all exposed fasteners with "LPS Procyon" batch: 5133690

240 - (QC5- Inspect part completeness to step on W/O)
 250 - (Pick Kit)
 260 - (QC4- 100% Inspect kits for completeness)
 270 - (Identify as per dwg & Stock Location: F6072) Package as per PPP D350-636-012
 275 - (Document Control) record fwd angle: 899 Photocopy blue file and type labels per PPP D350-636-012 CHG 008
 280 - (QC21- Final Inspection - Work Order Release)

Job BOM

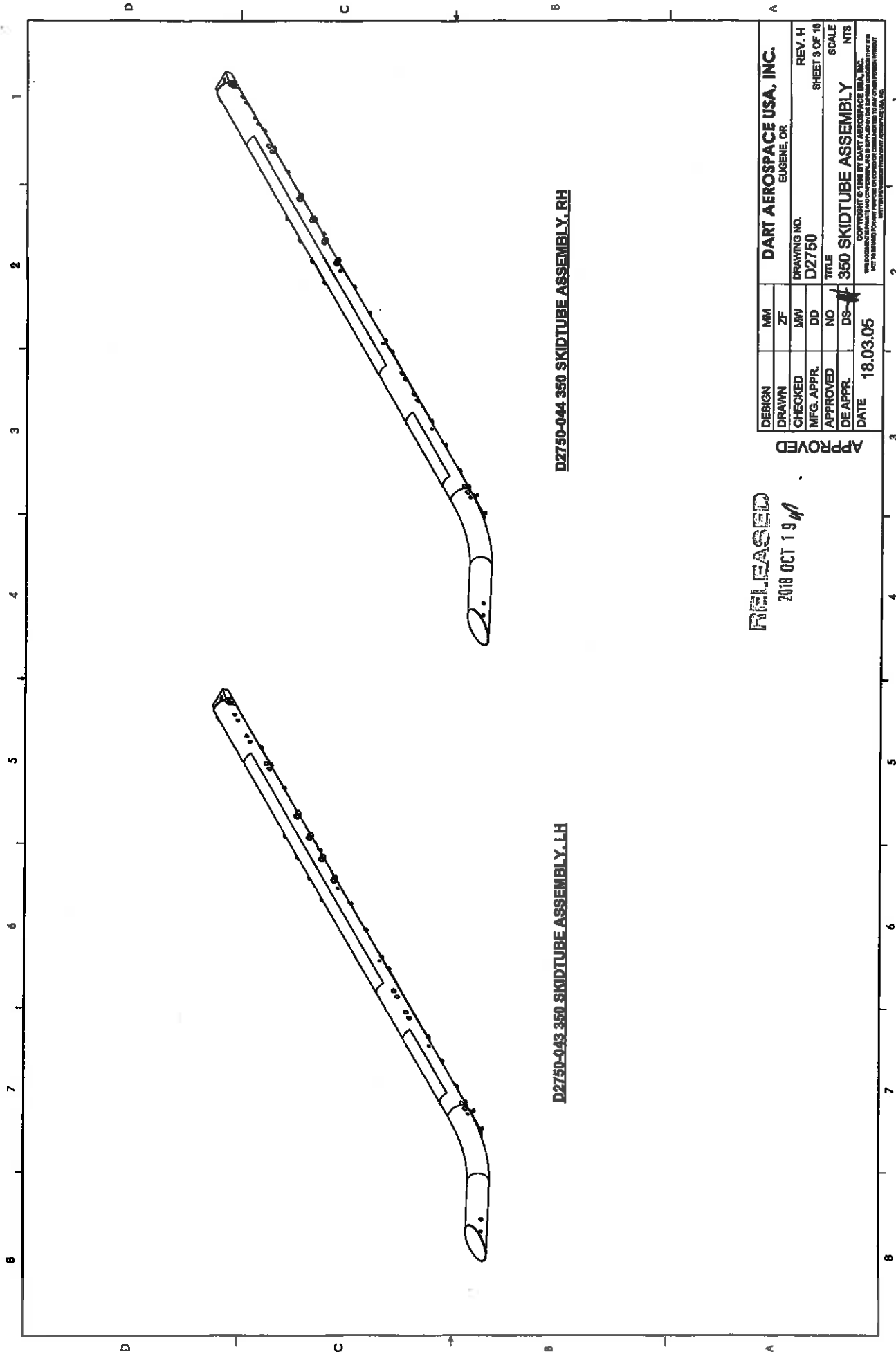
Part / Item	Component Name	Quantity	Operation
D2600-3-BENT-RH	Extrusion Bent RH	1 pcs (1 ea)	110-Skidtubes - 1
D2744	Cap	1 pcs (1 ea)	110-Skidtubes - 1
D2739	350 I-Beam	1 pcs (1 ea)	160-Skidtubes - 2 - B4B
D2743	Crossbolt Spacer	8 pcs (8 ea)	160-Skidtubes - 2 - B4B
D3490-1	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B
D3490-3	Cross Bolt Spacer	4 pcs (4 ea)	160-Skidtubes - 2 - B4B
ALS4-1032-225	Rivnut	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B
AN3C5A	Bolt	34 Ea (34 ea)	230-Handfinish - 4-1-Assembly-B4B
AN3C6A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B
AN6C44A	Bolt	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B
AN8C35A	Bolt	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B
D2745	Bushing	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B
D3488-4	Blade Fitting, RH	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B
D3492-1	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B
D3492-3	Plug	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B
D3537-1	Wearpad	3 pcs (3 ea)	230-Handfinish - 4-1-Assembly-B4B
D3631-1	Washer	8 pcs (8 ea)	230-Handfinish - 4-1-Assembly-B4B
D3791-1	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B
D3793-1	Wearplate Fwd	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B
D3793-3	Wearplate Aft	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B
MS21043-6	Nut	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B
MS21083C8	Nut	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B
NAS1149C0332R	Washer (AN960C10L)	38 Ea (38 ea)	230-Handfinish - 4-1-Assembly-B4B
NAS1149C0832R	Washer (AN960C816L)	1 Ea (1 ea)	230-Handfinish - 4-1-Assembly-B4B
NAS1515H3L	Washer	4 Ea (4 ea)	230-Handfinish - 4-1-Assembly-B4B
NAS1611-010	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B
NAS1611-013	O-Ring	8 Ea (8 ea)	230-Handfinish - 4-1-Assembly-B4B
D3793-5	Wearpad	1 pcs (1 ea)	230-Handfinish - 4-1-Assembly-B4B
AN8C21A	Bolt	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B
D2741	Replacement Blade	1 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B
D3493	Washer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B
D3532	Spacer	2 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B
MS21083C8	Nut	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B
NAS1149D0863J	Washer	2 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B

Container

012622
 521628D
 5192770
 5221693
 5194932
 5210529
 5222157 *3
 5203363
 5216219
 5217711
 5216233
 5217983
 5219776
 5215785
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 5163108
 5045308
 3166718

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - 1	D2600-3-BENT-RH	1	2	0
	D2744	1	38	0
160-Skidtubes - 2 - B4B	D2739	1	7	0
	D2743	8	143	0
	D3490-1	4	202	0
	D3490-3	4	33	0
	ALS4-1032-225	38	854	0
230-Handfinish - 4-1-Assembly-B4B	AN3C5A	34	689	0
	AN3C6A	4	95	0
	AN6C44A	4	60	0
	AN8C35A	1	13	0
	D2745	8	104	0
	D3488-4	1	18	0
	D3492-1	8	92	0
	D3492-3	8	50	0
	D3537-1	3	152	0
	D3631-1	8	256	0
	D3791-1	1	22	0
	D3793-1	1	30	0
	D3793-3	1	18	0
	D3793-5	1	27	0
	MS21043-6	4	48	0
	MS21083C8	1	46	0
	NAS1149C0332R	38	3,072	0
	NAS1149C0832R	1	269	0
	NAS1515H3L	4	43	0
	NAS1611-010	8	131	0
	NAS1611-013	8	128	0
250-Packaging 1-1 - Pick Kit - B4B	AN8C21A	2	81	0
	D2741	1	65	0
	D3493-1	2	37	0
	D3532-1	2	25	0
	MS21083C8	2	46	0
	NAS1149D0863J	2	349	0
Part Specifications				
Specifications could not be found.				

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D2750-044 350 SKIDTUBE ASSEMBLY, RH

D2750-043 350 SKIDTUBE ASSEMBLY, LH

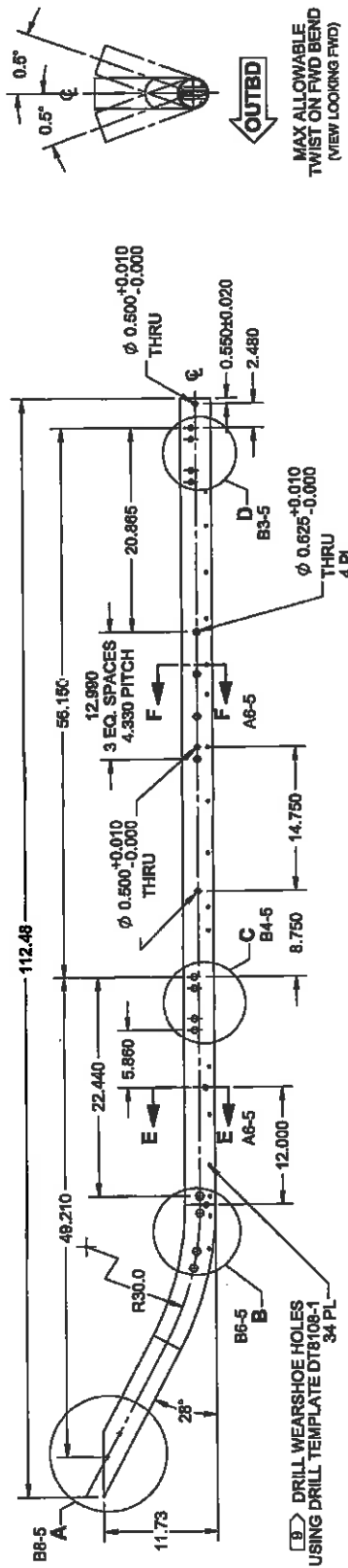
RELEASED
2018 OCT 19

APPROVED

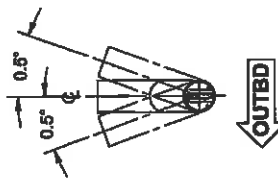
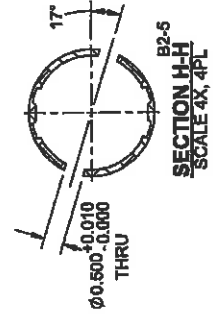
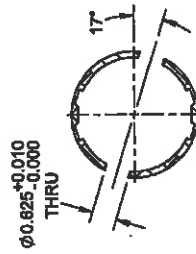
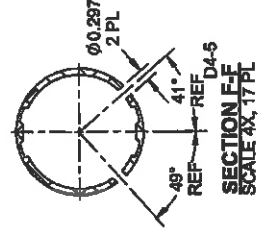
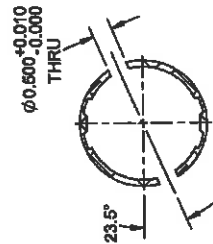
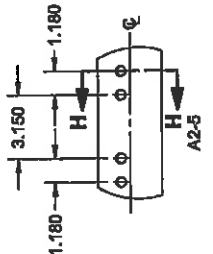
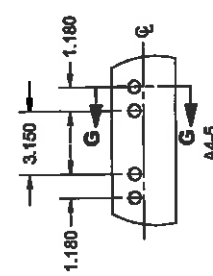
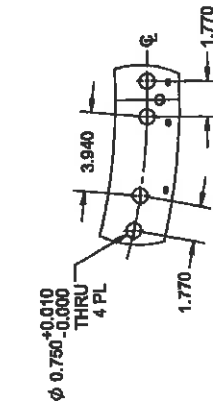
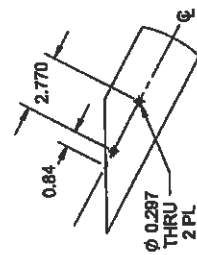
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN	ZF	EUGENE OR	
CHECKED	MMW	DRAWING NO.	REV. H
MFG. APPR.	DD	D2750	SHEET 3 OF 18
APPROVED	NO	TITLE	SCALE
DE APPR.	DS	350 SKIDTUBE ASSEMBLY	NTS
DATE	18.03.05		

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8 7 6 5 4 3 2 1



9 DRILL WEARSHOE HOLES
USING DRILL TEMPLATE DT8108-1
34 PL



RELEASED
2010 OCT 19

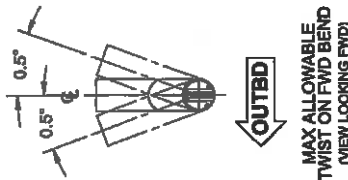
DART AEROSPACE USA, INC.
EUGENE, OR

DESIGN	MM	ZF	DRAWING NO.	REV. H
DRAWN			D2750	SHEET 5 OF 16
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	18.03.05			

APPROVED

350 SKIDTUBE ASSEMBLY

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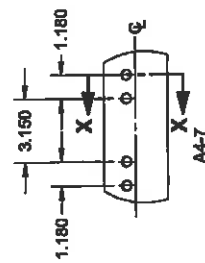
**MAX ALLOWABLE
TWIST ON FWD BEND
(VIEW LOOKING FWD)**

2.770

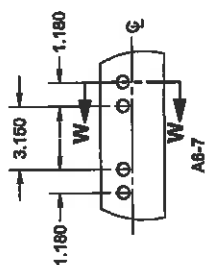
0.84

$\phi 0.297$
THRU
2 PL

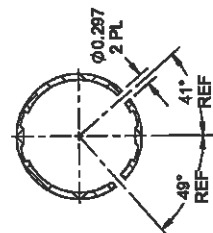
D7-7
DETAILS
SCALE 2X



D3-7
DETAIL U
SCALE 2X



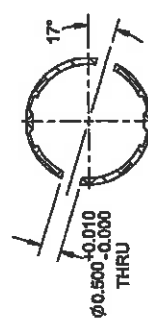
C5-7
DETAIL T
SCALE 2X



D4-7
SECTION V-V
SCALE 4X, 17 PL



B6-7
SECTION W-W



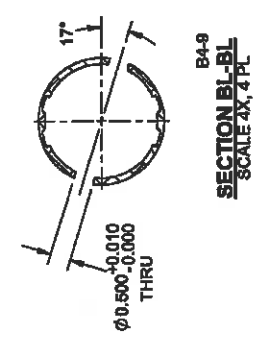
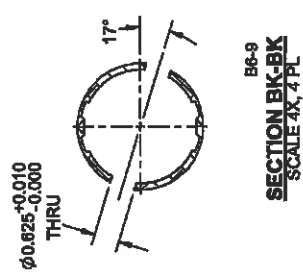
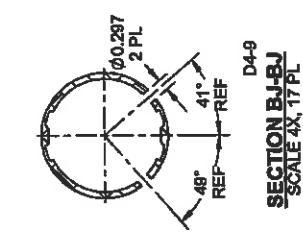
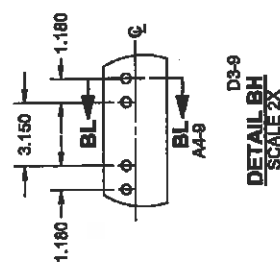
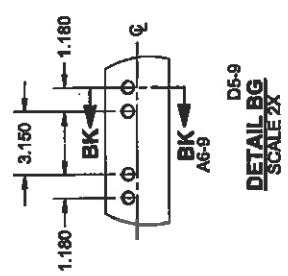
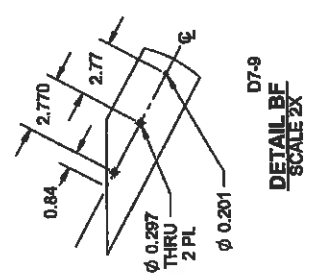
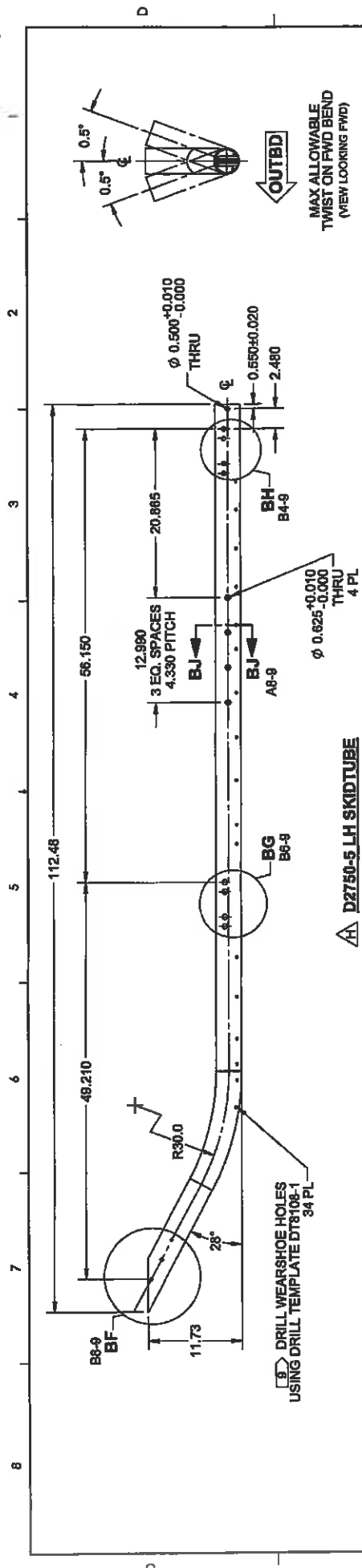
B4-7
SECTION X-X
SCALE 1/4" = 1'

61-150607
OCT 19 1961
RELEASED

[illegible]

APPROVED

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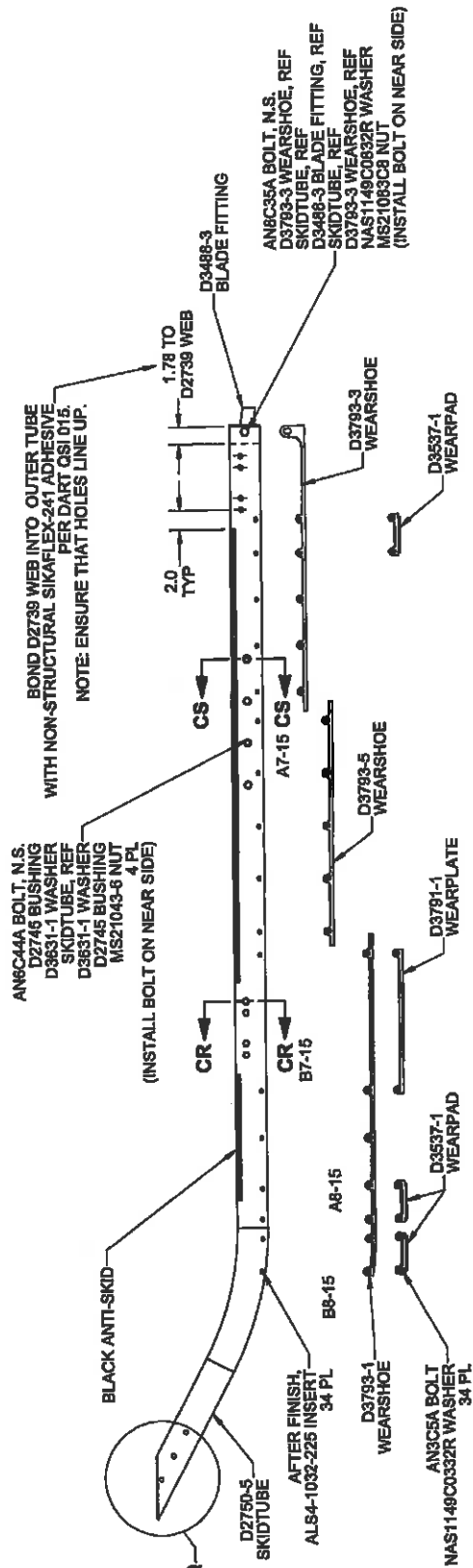


RELEASED
 2019 OCT 19

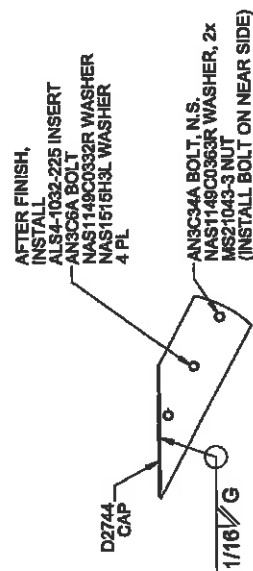
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CHECKED	MM	MM	MM	MM	MM		
MFG. APPR.	MM	MM	MM	MM	MM		
APPROVED	MM	MM	MM	MM	MM		
DE APPR.	MM	MM	MM	MM	MM		
DATE	18.03.05						

DART AEROSPACE USA, INC.
 EUGENE, OR
 REV. H
 DRAWING NO.
 D2750
 SHEET 9 OF 18
 TITLE
 350 SKIDTUBE ASSEMBLY
 SCALE
 NTS
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1 2 3 4 5 6 7 8



D2750-051 350 SKIDTUBE ASSEMBLY, LH



RELEASED

2018 OCT 19 02

DART AEROSPACE USA, INC.				350 SKIDTUBE ASSEMBLY			
DESIGN	MM	MM	MM	REV. H	EUGENE, OR		
DRAWN	ZF			DRAWING NO.	D2750		
CHECKED	MW			SHEET 15 OF 18			
MFG. APPR.	DD			TITLE	350 SKIDTUBE ASSEMBLY		
APPROVED	NO			SCALE	N/A		
DE APPR.	DS			DATE	18.03.05		



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Skid-tube ☐ ☐ ☐
Machining ☐ ☐ ☐
Large Fab ☐ ☐ ☐

Cross tube ☐ ☐ ☐
Small Fab ☐ ☐ ☐
Finishing ☐ ☐ ☐

Eng. (Non-AW) ☐ ☐ ☐
Prod. Eng. Coord. ☐ ☐ ☐
Rec/Store/Packaging ☐ ☐ ☐
Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐
Material ☐ ☐ ☐
Product Improvement ☐ ☐ ☐
Process Improvement ☐ ☐ ☐
Human Factors ☐ ☐ ☐

FAULT CATEGORY

Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong
Bending	Misaligned/off center	Folio/Program	Outside Tolerance
Crushing	BOM/Route	Grain Direction	Drawing
Cracks	Broken/Damage/Defect	Weld	Finish
Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing
Marks/Chatter	Drill Holes	Out of Sequence	Misread
Mislabeled	Fit/Function	Off-set/Set-up	

Other/Details: _____

5.0 PARTS LIST

D350-636-011/-012/-013/-014 SKIDTUBES AT CHG 008 AND SUBSEQUENT
D350-636-021/-022 SKIDTUBES AT CHG 001 AND SUBSEQUENT

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -021	Qty -022	Qty -049	Part Number	Description
	X							D350-636-011	SKIDTUBE INSTALLATION, LH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
		X						D350-636-012	SKIDTUBE INSTALLATION, RH, AERAZUR/DART CYLINDRICAL FLOAT COMPATIBLE
			X					D350-636-013	SKIDTUBE INSTALLATION, LH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE
				X				D350-636-014	SKIDTUBE INSTALLATION, RH AIRCRAUSER/DART TRI-BAG FLOAT COMPATIBLE
					X			D350-636-021	SKIDTUBE INSTALLATION, LH, STD
						X		D350-636-022	SKIDTUBE INSTALLATION, RH, STD
							X	D350-636-049	WEARSHOE KIT
1	1							D2750-041	SKIDTUBE ASSEMBLY, LH
1		1						D2750-042	SKIDTUBE ASSEMBLY, RH
1			1					D2750-043	SKIDTUBE ASSEMBLY, LH
1				1				D2750-044	SKIDTUBE ASSEMBLY, RH
1					1			D2750-051	SKIDTUBE ASSEMBLY, LH
1						1		D2750-052	SKIDTUBE ASSEMBLY, RH
*1	1							D2750-1	SKIDTUBE WELDMENT, LH
*1		1						D2750-2	SKIDTUBE WELDMENT, RH
*1			1					D2750-3	SKIDTUBE WELDMENT, LH
*1				1				D2750-4	SKIDTUBE WELDMENT, RH
1					1			D2750-5	SKIDTUBE WELDMENT, LH
1						1		D2750-6	SKIDTUBE WELDMENT, RH
**2	8	8	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8	8	8		22541N120	NUT
*5	1	1	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1	1	1		NAS1149C0832R	WASHER
*7	1	1	1	1	1	1		MS21083C8	NUT
8	1		1		1			D3488-3	BLADE FITTING, LH
8		1		1		1		D3488-4	BLADE FITTING, RH
9	1	1	1	1	1	1		D2744	BLADE
10	2	2	2	2	2	2		AN8C21A	BOLT
11	2	2	2	2	2	2		NAS1149DO863J	WASHER
11C							8	D3672-1	WASHER
12	2	2	2	2	2	2		MS21083CF	NUT
*14	4	4	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8	8	8		D2745	BUSHING
*16	4	4	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4	4	4		NAS1149C0332R	WASHER
*20B	4	4	4	4	4	4		NAS1515H3L	WASHER
*22	3	3	3	3	3	3	3	D3537-1	WEARPAD

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Revision: K
Date: 18.04.04

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -021	Qty -022	Qty -049	Part Number	Description
*22A	1	1	1	1	1	1	1	D3791-1	WEARPLATE
*23A	1	1	1	1	1	1	1	D3793-1	WEARSHOE (REPLACES D3535-13)
*24A	1	1	1	1	1	1	1	D3793-5	WEARSHOE (REPLACES D3535-25)
*25A	1	1	1	1	1	1	1	D3793-3	WEARSHOE (REPLACES D3535-35)
*26A	34	34	34	34	34	34	34	AN3C5A	BOLT
*27	34	34	34	34	34	34	34	NAS1149C0332R	WASHER
*28	34	34	34	34	34	34	34	ALS4-1032-225	INSERT
*30	8	8	8	8				D3492-041	PLUG ASSEMBLY
*31	8	8						D3492-043	PLUG ASSEMBLY
*32			8	8				D3492-045	PLUG ASSEMBLY
***43	2	2	2	2				D3493-1	WASHER
50	2	2						D3532-1	SPACER
****97					1	1		AN3C34A	BOLT
****98					2	2		NAS1149C0363R	WASHER
****99					1	1		MS21043-3	NUT
100A							4	AN526C1032R10	SCREW
100B							4	AN526C1032R18	SCREW

* PART OF D2750-041/-042, D2750-043/-044 OR D2750-051/-052 ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING A DART FLOAT SYSTEM

***** PART OF D2750-051 OR D2750-052 ASSEMBLY